

Work Order ID 77745

77745

Page 1

Tuesday, December 20, 2011 3:56:19 PM

Item ID: D2756

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Inner Doubler

Start Date: 12/20/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/22/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *WKR*

Date: 11-12-20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100

100

Shear

Shear

2024.040

SHEAR

Memo

blank: 4.5" X 4.5"

0.00

0.00

11-12-22

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Drill and cut corner radius per H2756 step 1 program. Debur

0.00

0.00

11-12-22

120

120

QC

Quality Control

QC 8 Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

8/12/22

7/12

122

QC 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77745

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Run Start *NR1*

Tooling:

Date:

Stop *NR2*

SPC (Y/N):

Date:

**Insp.
Stamp**

0.00

0.00

WMA 11-12-23

12

0.00

0.00

12 of March
count

11/12/28 sl 12

0.00

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77745***77745***

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Accept

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Revision ID:

Stop ***NS2***

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Start Date: 12/20/2011 Start Qty: 12.00

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Required Date: 12/22/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

11/12/28 

11.12.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 20, 2011 3:56:18 PM

Page 1

Work Order ID: 77745

Parent Item: D2756

Parent Item Name: Inner Doubler

Start Date: 12/20/2011

Required Date: 12/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B98.11.25New order of procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	33.3184	0.1458	1.8416842			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT022				33.318421					
				117684				33.318421					

B11-12-21

17684

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ☒ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

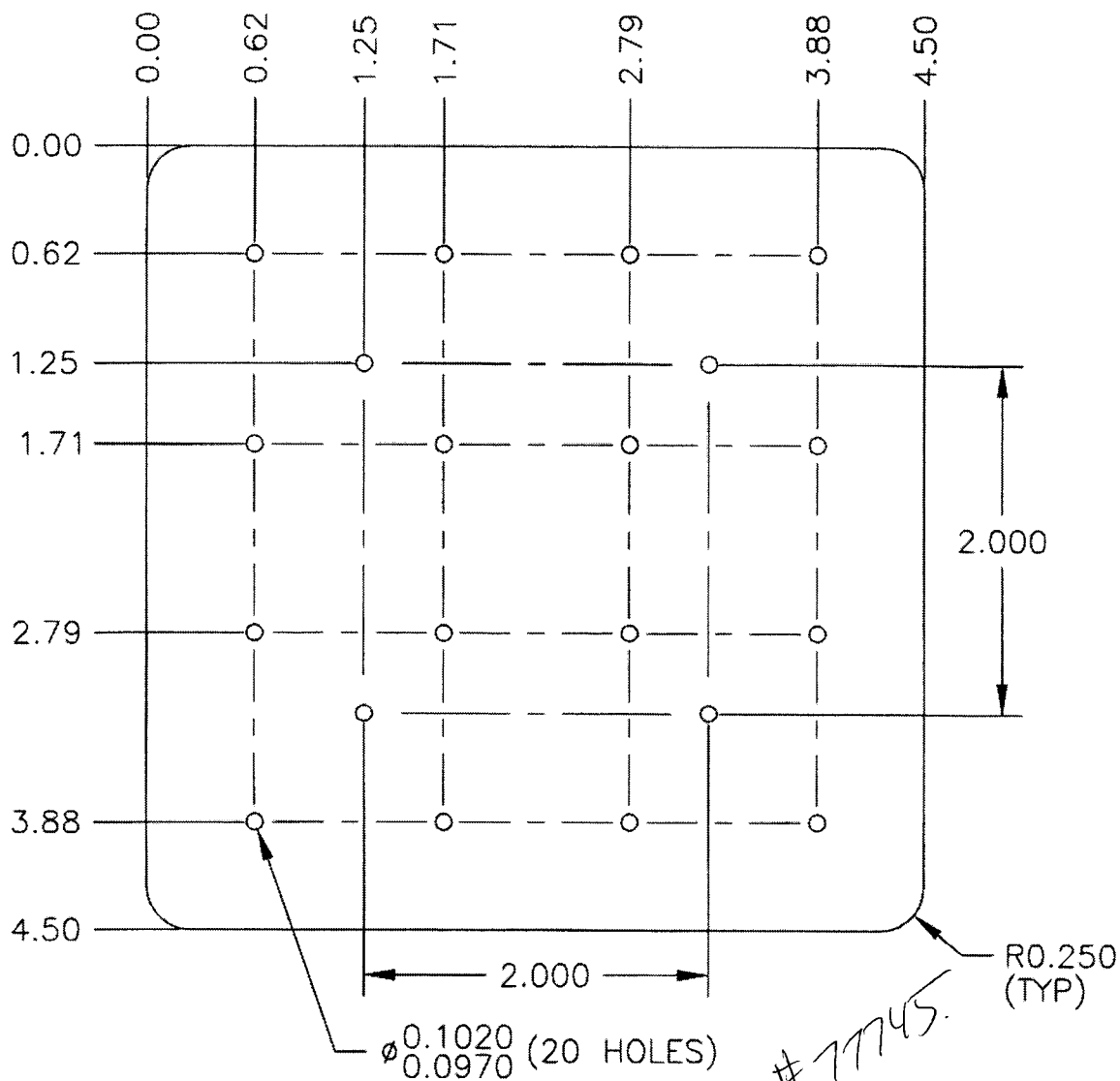
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>my</i>	APPROVED <i>CS</i>	DRAWING NO. D2756	REV. A SHEET 1 OF 1
DATE 98.04.01		TITLE INNER DOUBLER	SCALE 1:1
A	98.04.01	NEW ISSUE	

RELEASED
99/04/20 *KE*



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 77748
Description: INNER Doubler	Part Number: D2756
Inspection Dwg: D2756, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .097	+0.04 - .001	.106	2		VIS02	
.62	±.030	.621	2		V	
1.25	±.030	1.249	2		V	
1.71	±.030	1.712	2		V	
2.79	±.030	2.796	2		V	
3.88	±.030	3.881	2		V	
4.58	±.030	4.504	2		V	
2.000	±.010	2.000	2		V	
.040	±.010	.041	2		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-12-2022	Date: 11/12/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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